

**Work Order ID 54658**

December 15, 2009 3:26:18 PM

Page 1

Item ID: D2327-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacer Bushing

Start Date: 15/12/2009 Start Qty: 20.00

Required Date: 22/12/2009 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *PP*Date: *09-12-15*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2327

Rev D

100

0.00



Hardinge CNC LATHE SMALL

*SA 09/12/21*

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn per Folio FA232 and Dwg D2327 ☐ Debur*20* *φ*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

*SA 09/12/21*

QC

Memo

0.00

Quality Control

*20* *φ*

120

0.00



QC8- Inspect parts - second check

*SA 09/12/29*

QC

Memo

0.00

Quality Control

*20* *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54658**

Page 2

December 15, 2009 3:26:18 PM

Item ID: D2327-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer Bushing

Start Date: 15/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 22/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: basket

0.00



Packaging

Memo

0.00

Packaging

AD 10.01.04

140

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06

BS 10-1-04

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

December 15, 2009 3:26:22 PM

Page 1

Work Order ID: 54658



Parent Item: D2327-1



Parent Item Name: Spacer Bushing



Start Date: 15/12/2009

Required Date: 22/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	71.6135	3.7284			
												
304 ROUND BAR 0.375												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

71.61347895

112058

0.01317895

112473

11.6003

113325

60

55 SD 05/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	54658
<b>Description:</b> Spacer Bushing	<b>Part Number:</b>	D2327-1
<b>Inspection Dwg:</b> D2327 <b>Rev:</b> D		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	05/12/21	Date:	09/12/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.02.01	Tolerance revised for Ø0.375	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

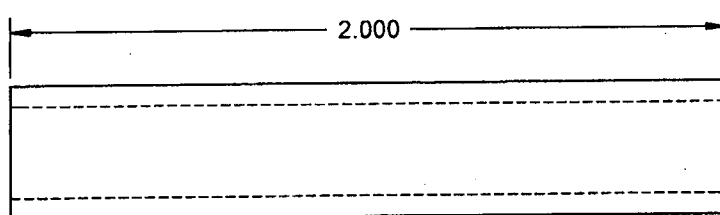
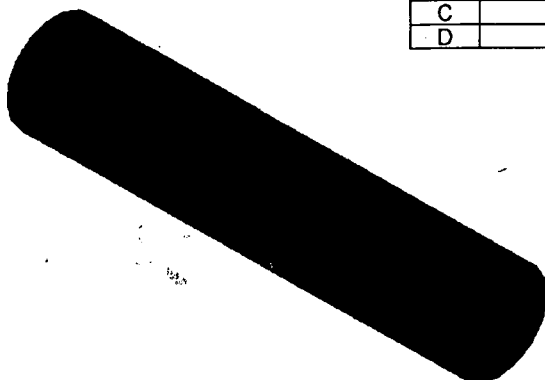
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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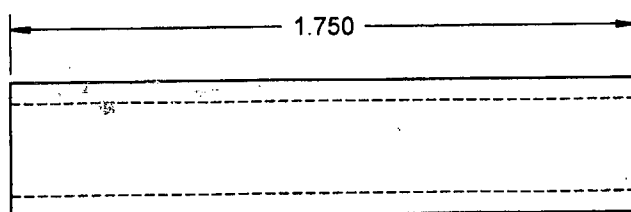
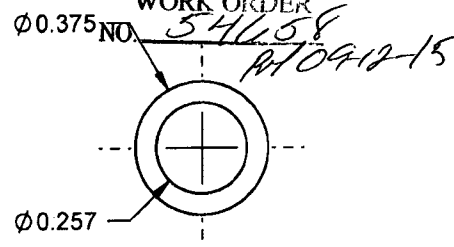
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED CH	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12	TITLE SPACER BUSHING		SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	



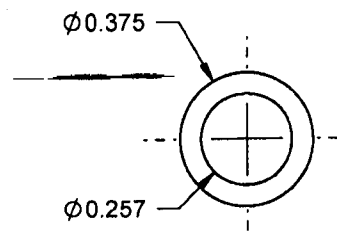
**D2327-1 SPACER BUSHING**

RELEASED  
06.11.14

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER



**D2327-3 SPACER BUSHING**



**NOTES:**

- 1) MATERIAL: AISI 304/316 SS,  $\phi 0.375$ , 0.065 WALL SEAMLESS ROUND TUBING  
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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